

**CLAIMS**

What is claimed:

- 5      1.      O-desmethylvenlafaxine prepared by reacting venlafaxine with a high molecular weight alkane or arene thiolate anion in an alcohol, ethylene glycol, ether of ethylene glycol, or mixture thereof, wherein the O-desmethylvenlafaxine contains no more than about 1% venlafaxine as an impurity.
- 10     2.      O-desmethylvenlafaxine prepared by demethylating venlafaxine with dodecyl thiolate and polyethylene glycol 400 in the presence of sodium methylate in methanol at about 180C to about 200 C for about 2 to about 5 hours and neutralizing the product to about pH 9.5 in the presence of isopropanol, wherein the O-desmethylvenlafaxine contains no more than about 1% venlafaxine as an impurity.

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